

## PHILADE SCRIPT MOLD - 14 TO 42 POINT

### DESCRIPTION & INSTRUCTIONS FOR FITTING ETC:-

This mold, one of which is required for each size, enables Type to be cast on the Super Center from Script Matrices, and the Type produced is of such a shape that the overhanging parts of the character are amply supported.

The required shape of Type is obtained by means of a special Top Blade, and plates on the Crossblock. Owing to the peculiar construction of the mold it is essential to positively locate the Crossblock at the casting position, this has been done by extending the Crossblock Backplate and altering its shape so that it now comes into contact with a fixed stop on the Mold Base.

In order to eject the Type from the Mold and to prevent damage to the Upper Blade(which is of rather delicate construction) the Lower Blade only is used for ejection and it travels a considerable distance further forward than a standard Mold Blade.

Should the Blade remain stationary in this forward position, while the Type Carrier continues to travel, the Blade would be damaged. (NOTE:- This could only happen if the Mold Blade seized up in the forward position). To prevent damage to the Blade under these conditions a Bag Block has been provided which prevents the Type Carrier moving forward until the lower Blade is clear.

**HOW TO ADJUST THE MACHINE - SUPER CASTER:-** Remove the following parts from the machine:-

- (1) Type Carrier complete with the Connecting Rod.
- (2) Wedge Screw Housing and Mold Blade Slide.
- (3) Mold Blade Slide Drive Lever Connecting Tube 35F.
- (4) Type Channel Blocks.
- (5) Type Pusher.

Assemble the special Type Carrier and connect up to the Laid in the Type Carrier Cam Lever Extension as follows:-

24 Pt.	hole for 14 to 24 Point.
35 Pt.	" " 26 & 36 "
42 Pt.	" " 42 Point.

Contd.

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**D.12723/1**

File clearance for Type Pusher Lever -see Drg.D-12723/1

Remove standard Latches from Type Channel Blocks,assemble the special Latches,and replace Blocks on machine.

Assemble the Type Pusher. Assemble Mould Blade Slide.

Turn Wedge Screw to its highest position and assemble wedge Screw Housing on machine.

Place Mould in position and connect Blade to Mould Blade Slide using the special Connecting Pin which can only be inserted when the Lower Blade is in the forward position. Adjust the Type Carrier Connecting Rod so that with the Greenblock in setting position,the Plunger #258012 is depressed  $\frac{1}{8}$  of an inch. (NOTE:- This Plunger must be oiled frequently).

Adjust the travel of the Type Pusher,so that in the forward position,the front of the Pusher comes just past the front of the special Type Channel Block Latches.

Assemble the special Mould Blade Slide Drive Lever Connecting Tube and connect the Bell End to the #8-60 Pt.hole in the Intermediate Lever for all Blade openings up to  $\frac{1}{8}$  inch,for wider openings up to 42 Set change to hole for 72 Pt.

Adjust the Tube so that with the lower Blade in its extreme forward position you get minimum compression (not more than  $\frac{1}{16}$ ) on the Spring #58971.

Check that the Safety Device is in engagement between the Mould Base and the Greenblock Backplate until the front of the Blade is just inside the front of the Side Blocks.

With Blade in this position,adjust the two screws in the Spring Thrust Plate at rear of the Wedge Screw Housing, so that the pin is out of contact with Mould Blade Slide.

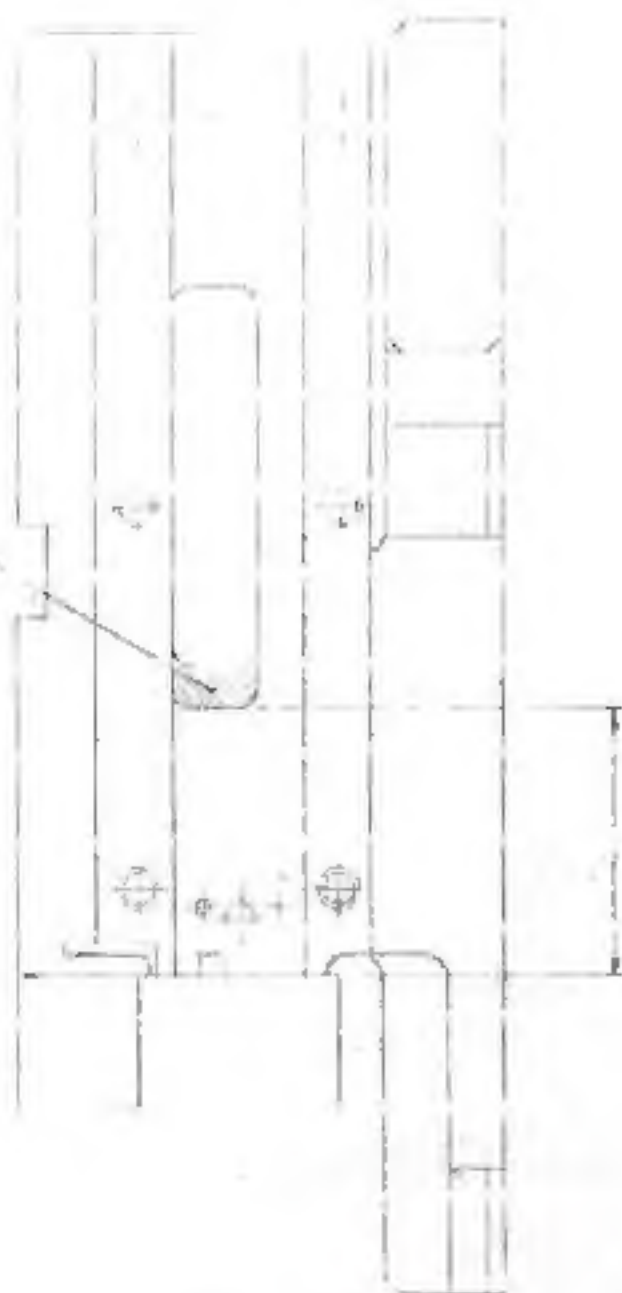
Assemble Bridge and Oiler on Mould. Line and size up for Body and set with Set Mark. Oil upper Blade,Greenblock and Safety mechanism frequently.

It may be necessary to file a clearance in underside of bridge so that safety gag block can be raised to its stop.

Machine should be operated at one speed lower than for Standard Moulds of similar size.

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REMOVE  
THIS PORTION



1/2" APPROX.

MATRIX HEADS BASE SHOWING

MODIFICATION REQUIRED WHEN

PLATE

FITTING/ SCRIPT MOLD ATTACHMENT.

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